

100-443887-100

5 copolymerization of ethylene or propylene with one another or with other olefinically unsaturated compounds.

The present invention further provides a process of this type which is carried out at from 20 to 300°C and pressures of from 5
10 to 4 000 bar, provides for the use of a complex of a transition metal with one or two substituted or unsubstituted 1,3,5-triazacyclohexane ligands or corresponding ligands in which one or more ring nitrogens are replaced by phosphorus or arsenic atoms in the copolymerization of ethylene or propylene with one
15 another or with other olefinically unsaturated compounds and also provides transition metal complexes with specifically substituted triazacyclohexane ligands.

Single site catalysts are gaining increasing importance in the
20 polymerization of olefins. These catalyst systems lead to
polymers having narrow molecular weight distributions, which
results in particularly favorable mechanical properties. Among
these single site catalysts, metallocene catalysts have achieved
particular industrial importance. However, many metallocene
25 catalysts can be obtained only by means of multistage syntheses
and therefore represent a significant cost factor in olefin
polymerization.

Triazacyclohexane and its derivatives, which differ in having
30 different substitution patterns, have been known for a long time
and are used in a variety of ways in industry since they can be
prepared in a simple and inexpensive manner from simple starting
materials. Thus, for example, triazacyclohexane derivatives are
used in the desulfurization of kerosene. However, the use of
35 triazacyclohexane and its derivatives as ligands in the
preparation of organometallic complexes is not widespread. Only
isolated reports of complexes with these ligands have appeared in
the organometallic literature, for example in N.L. Armanasco,
M.V. Baker, M.R. North, B.W. Skelton, A.H. White, J.Chem. Soc.,
40 Dalton Trans. (1997), 1363-1368; H. Schumann, Z. Naturforsch.,
part B50 (1995), 1038-1043; R.D. Köhn, et al. Angew. Chem. Int.
Ed. Engl. 33 (1994), 1877-1878; J. Organomet. Chem. 501 (1995),
303-307; Chem. Ber. 129 (1996), 25-27; J. Organomet. Chem 520
(1996), 121-129; Inorg. Chem. 36 (1997), 6064-6069; Chem. Ber.
45 129 (1996), 1327-1333. Triazacyclohexane complexes in the

polymerization of olefins has, however, been unknown until recently.

At the [lacuna] in Dallas, Texas, one of the inventors of the present patent application reported the first experiments on the polymerization of ethylene using an N,N,N-trioctyltriaza-cyclohexane-chromium complex and methylaluminoxane as activator. However, nothing was said about the suitability of the catalyst system for copolymerization; it was merely remarked that contact of the catalyst system with 1-hexene leads selectively to trimerization. [sic]

At the 213th ACS National Meeting, April 13 - April 17, 1997 in San Francisco and the 215th ACS National Meeting, March 29 - April 2, 1998 in Dallas, Texas, one of the inventors of the present patent application reported the first experiments on the polymerization of ethylene using an N,N,N-trioctyltriaza-cyclohexane-chromium complex and methylaluminoxane as activator. However, nothing was said about the suitability of the catalyst system for copolymerization; it was merely remarked that contact of the catalyst system with 1-hexene leads selectively to trimerization.

In JP-A-10 231317, symmetrically substituted triazacyclohexane-chromium complexes, inter alia, are used together with tris(pentafluorophenyl)borane and aluminum alkyl for preparing polymers and oligomers in solution or suspension. The polymers obtained often contain relatively large amounts of low molecular weight products and therefore have a broad molecular weight distribution. Nothing was said about the suitability of the catalyst system for copolymerization.

It is an object of the present invention to find a process for the polymerization of olefins, in particular of ethylene or propylene with one another or with other olefinically unsaturated compounds, which is based on a catalyst system which has good polymerization activity and can be prepared in a simple and inexpensive manner from simple starting materials.

We have found that this object is achieved by a process for the copolymerization of ethylene or propylene with one another or with other olefinically unsaturated compounds, wherein the polymerization is carried out in the presence of a catalyst system comprising the following components:

3

A) a complex of a transition metal with one or two substituted or unsubstituted 1,3,5-triazacyclohexane ligands or corresponding ligands in which one or more of the ring nitrogens are replaced by phosphorus or arsenic atoms, and

5

B) if desired, one or more activator compounds.

We have also found the use of such a complex of a transition metal (A) in the copolymerization of ethylene or propylene with
10 one another or with other olefinically unsaturated compounds.

The invention also provides a process for the copolymerization of ethylene or propylene with one another or with other olefinically unsaturated compounds at from 20 to 300°C and pressures of from 5
15 to 4 000 bar, which comprises the following process steps:

a) bringing a complex of a transition metal with one or two substituted or unsubstituted 1,3,5-triazacyclohexane ligands (A) into contact with at least one activator compound (B)

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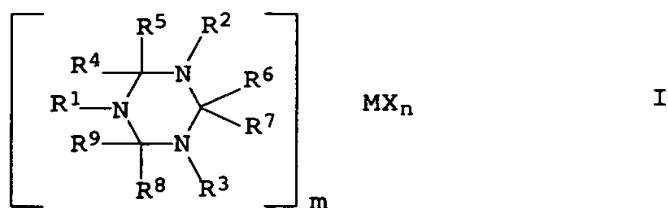
b) bringing the reaction product from step (a) into contact with the olefinically unsaturated compounds under polymerization conditions.

25 Step b) can be carried out after step a), but also simultaneously with a).

In one embodiment of the process of the present invention, the component (A) used is a compound of the formula I

30

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where the variables have the following meanings:

40 M is a transition metal of groups 4 to 12 of the Periodic Table,

R¹-R⁹ are hydrogen or organosilicon or organic substituents having from 1 to 30 carbon atoms, where two geminal or
45 vicinal radicals R¹ to R⁹ may also be joined to form a 5- or 6-membered ring and, when m is 2, a radical R¹-R⁹ of in each case one triazacyclohexane ring together with one of

the substituents from the other triazacyclohexane ring may also form a bridge between the two rings,

- X is fluorine, chlorine, bromine, iodine, hydrogen,
- 5 C₁-C₁₀-alkyl, C₆-C₁₅-aryl or alkylaryl having from 1 to 10 carbon atoms in the alkyl part and from 6 to 20 carbon atoms in the aryl part, trifluoroacetate, BF₄⁻, PF₆⁻ or a bulky noncoordinating anion,
- 10 m is 1 or 2,
- n is a number from 1 to 4 corresponding to the oxidation state of the transition metal M.
- 15 Suitable transition metals M are, in particular, the elements of groups 4 to 8 of the Periodic Table and especially the elements of group 6 of the Periodic Table. Particularly useful central atoms in the transition metal complexes used according to the present invention are the elements titanium, zirconium, hafnium,
- 20 vanadium, chromium, molybdenum, tungsten, manganese, iron, rhodium and nickel. Particular preference is given to using transition metal complexes of chromium.
- Variation of the substituents on the triazacyclohexane ring
- 25 system allows various properties of the catalyst system to be influenced. Thus, the catalyst activity can generally be increased by the introduction of substituents, in particular on the nitrogen atoms of the ring system. Furthermore, the ability of the polyolefins to be polymerized to gain access to the
- 30 central atom can be influenced by means of the number and type of the substituents. This also allows the activity of the catalyst, the selectivity in respect of various monomers, in particular bulky monomers, and the molecular weight of the resulting polymers to be influenced. The chemical structure of the
- 35 substituents R¹ to R⁹ can therefore be varied within a wide range in order to achieve the desired results and to obtain a tailored catalyst system. Possible organic substituents are, for example, C₁-C₁₈-alkyl, 5- to 7-membered cycloalkyl which may in turn bear a C₁-C₁₀-aryl group as substituent, C₆-C₁₅-aryl or arylalkyl, where,
- 40 if desired, two geminal or vicinal radicals R¹ to R⁹ may also be joined to form a 5- or 6-membered ring. Possible organosilicon substituents are, in particular, trialkylsilyl groups having from 1 to 10 carbon atoms in the alkyl radical, in particular trimethylsilyl groups. If the transition metal complex contains
- 45 only one triazacyclohexane ligand, i.e. m = 1, one of the substituents R¹ to R⁹ can also bear a donor group which is connected via a bridge to the ring system and occupies a

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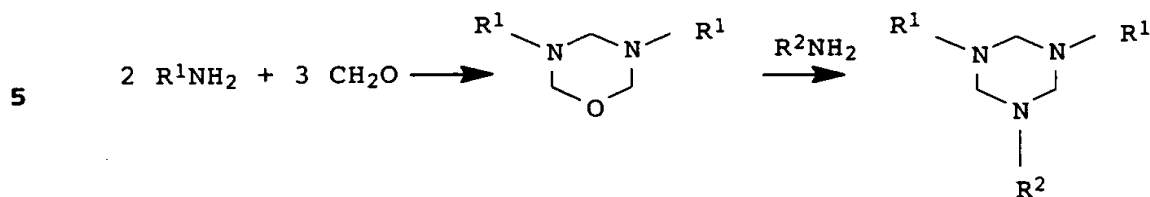
- coordination position around the metal atom. Possible donor groups of this type are, in particular, nitrogen-containing functions such as dialkylamino groups. If the transition metal complex bears two triazacyclohexane ligands, i.e. m is 2, a
- 5 radical R^1 to R^9 together with one of the substituents from the other triazacyclohexane ring may also form a bridge between the two rings. Possible bridges are all bridges which are known to a person skilled in the art, for example from similar metallocene complexes, i.e. especially silyl- or carbon-containing bridges.
 - 10 As in the case of the metallocene complexes, bridged complexes having various symmetries (e.g. C_s , C_{2v}) have the advantage that they are suitable for preparing syndiotactic or isotactic polypropylene.
 - 15 However, triazacyclohexane ligands having simple substitution patterns can also be used advantageously, particularly for preparing polyethylene or for preparing copolymers of ethylene with higher α -olefins. Thus, for example, very good polymerization results can be achieved using transition metal
 - 20 complexes which have only one triazacyclohexane ring which is substituted by simple C_1 - C_{12} -alkyl radicals on the nitrogen atom. Possible alkyl substituents are, in particular, methyl, ethyl, propyl, butyl, hexyl and octyl radicals. In an advantageous embodiment of the process of the present invention, R^1 , R^2 and R^3
 - 25 are therefore C_1 - C_{12} -alkyl or C_6 - C_{15} -aryl or arylalkyl. In a further advantageous embodiment of the process, the substituents R^4 , R^5 , R^6 , R^7 , R^8 and R^9 are hydrogen or C_1 - C_4 -alkyl. Hydrogen or methyl groups are particularly useful as R^4 , R^5 , R^6 , R^7 , R^8 and R^9 , since such derivatives can be prepared particularly simply as
 - 30 condensation product of formaldehyde or acetaldehyde with appropriate amines.

- Possible substituents X are, in particular, halogens, especially chlorine. Simple alkyl radicals such as methyl, ethyl, propyl or
- 35 butyl are also advantageous ligands X . Further ligands X which may be mentioned purely by way of example and do not constitute an exhaustive listing are trifluoroacetate, BF_4^- , PF_6^- and noncoordinating anions such as $B(C_6F_5)_4^-$. The number of ligands X depends on the oxidation state of the transition metal M . The
 - 40 number n can thus not be defined generally, but can assume different values for each particular transition metal. These values, i.e. the oxidation states of the individual transition metals in catalytically active complexes, are known to those skilled in the art. Thus, the appropriate complexes of titanium,
 - 45 zirconium and hafnium have, in particular, the oxidation state +4, chromium, molybdenum and tungsten are preferably present in

the oxidation state +3, while iron and nickel are preferably used in the oxidation state +2.

A particularly large number of variation opportunities for preparing tailored catalyst systems are conceivable when the substitution pattern of the complexing ligands is unsymmetrical. Preference is therefore also given to transition metal complexes of the formula I in which at least one of the radicals R^1 , R^2 or R^3 is different from the other two of these radicals. Such unsymmetrically substituted triazocyclohexane complexes or the ligands on which these complexes are based can, for example, be prepared by the following methods:

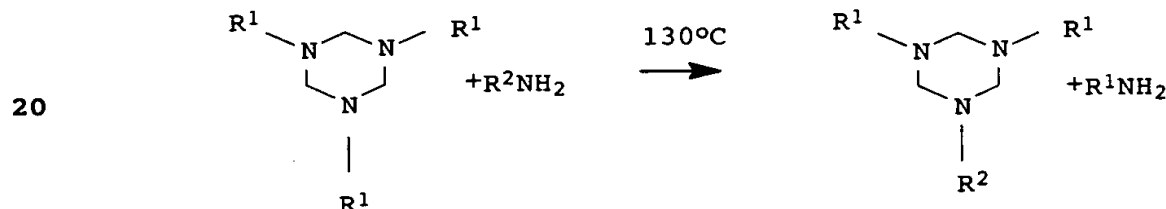
- 1) By reaction of a mixture of two primary amines (R^1NH_2 and R^2NH_2) with formaldehyde (aqueous solution or paraformaldehyde), which leads to a mixture of various products which can be separated as follows:
 - a) Distillation of the product when R^1 and R^2 are sufficiently small.
 - b) Carrying out the reaction using a large excess of the amine R^1NH_2 , when the symmetrical reaction product can be distilled off. The unsymmetrical product then remains after distillation.
 - c) Selective crystallization of one product.
 - d) Complexing of the mixture by means of $CrCl_3$ and separation of the complexes by column chromatography.
- 2) By reaction of an amine R^1NH_2 with an excess of formaldehyde to give a mixture of symmetrically substituted product and the corresponding 1-oxa-3,5-diazacyclohexane. In a second step, the 1-oxa-3,5-diazacyclohexane can be reacted under normal conditions with another amine R^2NH_2 (possibly in the presence of an acid catalyst) so as to replace the oxygen by R^2N . The separation of the product mixture can be carried out as under 1):



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- 3) By reaction of a symmetrical triazacyclohexane having a small radical R^1 (Me or Et) with another amine R^2NH_2 at about 130°C . At this temperature, R^1NH_2 is given off and a mixture of the conceivable unsymmetrical triazacyclohexanes is formed. The separation is carried out as under 1):

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- 4) By reaction of two different symmetrical triazacyclohexanes with one another. Exchange of substituents can occur in a slow reaction. The products can be separated as under 1).

30 Bridged triazacyclohexanes can also be obtained by these methods.

A bridge between two triazacyclohexane ligands makes it possible to obtain chiral complexes which can be used advantageously for the preparation of tactic polypropylene. In addition, the bridge
 35 also sets an opening angle on the active center of the catalyst complex by means of which further polymerization properties can be adjusted. Particular preference is therefore also given to transition metal complexes of the formula I in which m is 2 and a radical R^1 to R^9 of in each case one triazacyclohexane ring
 40 together with one of the substituents from the other triazacyclohexane ring forms a bridge between the two rings.

The process of the present invention for the polymerization of olefins can be combined with all industrially known
 45 polymerization processes. The advantageous pressure and temperature ranges for carrying out the process therefore depend strongly on the polymerization method. The catalyst systems used

according to the present invention can thus be employed in all known polymerization processes, i.e., for example, in high-pressure polymerization processes, in tube reactors or autoclaves, in suspension polymerization processes, in solution polymerization processes or in gas-phase polymerization. In the case of high-pressure polymerization processes, which are usually carried out at pressures in the range from 1 000 to 4 000 bar, in particular from 2 000 to 3 500 bar, high polymerization temperatures are also set as a rule. Advantageous temperature ranges for these high-pressure polymerization processes are from 200 to 380°C, in particular from 220 to 270°C. In the case of low-pressure polymerization processes, the temperature set is generally at least a few degrees below the softening temperature of the polymer. In particular, temperatures in the range from 50 to 180°C, preferably from 70 to 120°C, are set in these polymerization processes. The pressures here are usually in the range from 1 to 40 bar, preferably from 5 to 40 bar. Among the abovementioned polymerization processes, gas-phase polymerization, in particular in gas-phase fluidized-bed reactors, and suspension polymerization, in particular in loop reactors, are particularly preferred according to the present invention.

Various olefinically unsaturated compounds can be polymerized by the process of the present invention. In contrast to some known iron and cobalt complexes, the transition metal complexes used according to the present invention display good polymerization activity even in the case of higher α -olefins and polar comonomers, so their suitability for copolymerization is worthy of particular mention. Possible olefins are particularly ethylene and α -olefins having from 3 to 8 carbon atoms, but also dienes such as butadiene and polar monomers such as acrylic esters and vinyl acetate. Vinylaromatic compounds such as styrene can also be polymerized by the process of the present invention.

In a preferred embodiment of the process of the present invention, monomers used are mixtures of ethylene with C_3 - C_8 - α -olefins such as propene, 1-butene, 1-pentene, 1-hexene, 1-heptene or 1-octene.

Some of the metal complexes designated as component (A) are themselves not polymerization-active and then have to be brought into contact with an activator, viz. component (B), in order to be able to display polymerization activity. Possible activator compounds are, for example, those of the aluminoxane type, in particular methylaluminoxane. Aluminoxanes are prepared, for example, by controlled addition of water to alkylaluminum

compounds, in particular trimethylaluminum. Aluminoxane preparations suitable as cocatalyst are also commercially available. It is assumed that these are mixtures of cyclic and linear compounds. The cyclic aluminoxanes can be represented by the formula $(R^{10}AlO)_k$ and the linear aluminoxanes by the formula $R^{10}_2Al(R^{10}AlO)_kR^{10}$, where k can be from 1 to 50. R^{10} is preferably a C_1 - C_6 -alkyl, e.g. methyl, ethyl, butyl or isobutyl, particularly preferably methyl. It is also possible for various radicals R^{10} to be present in an aluminoxane. Advantageous aluminoxanes comprise essentially aluminoxane oligomers having a degree of oligomerization of from about 5 to 30.

As well as aluminoxanes, it is also possible to use activator components as are employed in the cationic activation of metallocene complexes. Such activator components are known from, for example, EP-B1-0468537 and EP-B1-0427697. In particular, boranes or borates can be used as such activator compounds (B). Particular preference is given to using boranes or borates which bear at least two substituted aryl radicals. A particularly useful borate is dimethylanilinium tetrakis(pentafluorophenyl)borate, and a particularly preferred borane is tris(pentafluorophenyl)borane.

Further activator components which can be used are compounds such as aluminum alkyls, in particular trimethylaluminum, aluminum trifluoride or perchlorates. The aluminum alkyls can at the same time be used for reacting with and thus removing water or other impurities.

It is sometimes desirable to use a combination of various activators. This is known, for example, in the case of metallocenes where boranes and borates are often used in combination with an aluminum alkyl. A combination of various activator components with the transition metal complex used according to the present invention is generally also possible.

The amount of activator compounds to be used depends on the type of activator. In general, the molar ratio of transition metal complex (A) to activator compound (B) can be from 1:0.1 to 1:10 000, preferably from 1:1 to 1:1 000. The molar ratio of transition metal complex (A) to dimethylanilinium tetrakis(pentafluorophenyl)borate is preferably in the range from 1:1 to 1:20 and particularly preferably from 1:1 to 1:15, while that to methylaluminoxane is preferably in the range from 1:1 to 1:3 000, and particularly preferably from 1:10 to 1:500. The amount of activator compound can be used to control not only the activity of the catalyst but also polymer properties such as the

molecular weight. The optimum amount accordingly varies as a function of the desired activity/polymer properties and depending on the respective transition metal complex and can be determined by simple experimentation.

5

The transition metal complex can be brought into contact with the activator compound or compounds either before or after it is brought into contact with the olefins to be polymerized. Preactivation using one or more activator compounds prior to

10 mixing with the olefin and further addition of the same or different activator compounds after this mixture has been brought into contact with the olefin is also possible. Preactivation is generally carried out at 10-100°C, preferably 20-80°C.

15 It is also possible for more than one of the transition metal complexes used according to the present invention to be simultaneously brought into contact with the olefin to be polymerized. This has the advantage that a further range of polymers can be produced in this way. For example, bimodal
20 products can be prepared in this manner.

A likewise broad product spectrum can be achieved by use of the complexes employed according to the present invention in the presence of a catalyst customary for the polymerization of

25 olefins. Catalysts which can be used here are, in particular, classical Ziegler-Natta catalysts based on titanium, classical Phillips catalysts based on chromium oxides, metallocenes (cf., for example, Coville et al., J. Orgmet. Chem. 479 (1994) 1-29), constrained geometry complexes (cf., for example, EP-A-416815 or
30 EP-A-420436), nickel- and palladium-bisimine systems (for the preparation of these, see WO-A-98/03559), iron- and cobalt-pyridinebisimine compounds (for the preparation of these, see WO-A-98/27124) or titanium- and zirconium-Schiff base complexes (cf., for example, EP-A-874 005). Thus, for example,
35 bimodal products can also be prepared or comonomers can be generated in situ by means of such combinations.

The transition metal complexes (A) used according to the present invention can also optionally be immobilized on an organic or

40 inorganic support and be used in supported form in the polymerization. In this way, catalysts for the polymerization of olefins which comprise at least one transition metal complex (A) and, if desired, one or more activator compounds (B) and a support material are obtained. This is a customary method of
45 avoiding deposits in the reactor and of controlling the polymer morphology. Support materials used are preferably silica gel, magnesium chloride, aluminum oxide, mesoporous materials,

aluminosilicates and organic polymers such as polyethylene, polypropylene or polystyrene, in particular silica gel or magnesium chloride. The support material can also be dried or calcined prior to being brought into contact with the transition
5 metal complex or the activator compound.

The activator compound(s) (B) and one or more transition metal complexes (A) can be brought into contact with the support material in various orders or simultaneously. This is generally
10 carried out in an inert solvent which is separated off by filtration or evaporated after the immobilization. It is also possible to use the supported catalysts while still moist. Thus, the mixture of the support material can firstly be brought into contact with the activator compound or compounds (B) or the
15 support material can firstly be brought into contact with the transition metal complex (A). It is also possible for the transition metal complex (A) to be precontacted with one or more activator compounds (B) prior to mixing with the support. The preferred procedure is for a mixture of the transition metal
20 complex (A) with one or more activator compounds (B) to be mixed with the support material and subsequently dried. The amount of metal complex (A) (in mmol) per gram of support material can vary greatly, e.g. between 0.001 to 1 mmol/g. The preferred amount of metal complex (A) per gram of support material is in the range
25 from 0.001 to 0.5 mmol/g, particularly preferably from 0.005 to 0.1 mmol/g. In a possible embodiment, the metal complex (A) can also be prepared in the presence of the support material. A further method of immobilization is prepolymerization of the catalyst system with or without prior application to a support.

30 These supported catalyst systems are particularly useful in processes for the polymerization or copolymerization of olefins. Possible olefins include not only ethylene and α -olefins having from 3 to 12 carbon atoms but also internal olefins and
35 nonconjugated and conjugated dienes such as butadiene, 1,5-hexadiene or 1,6-heptadiene, cyclic olefins such as cyclohexene, cyclopentene or norbornene, polar monomers such as acrylic esters, acrolein, acrylonitrile, vinyl alcohol and vinyl acetate or vinylaromatic compounds such as styrene. Preference is
40 given to polymerizing at least one olefin selected from the group consisting of ethene, propene, 1-butene, 1-pentene, 1-hexene, 1-heptene, 1-octene and 1-decene. In a preferred embodiment of the process of the invention, the monomers used are mixtures of ethylene or propylene with one another or with C₄-C₁₂- α -olefins.

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The process of the present invention makes it possible to prepare polymers and copolymers of olefins over a broad molecular weight range.

- 5 The preparation of various triazacyclohexane ligands has been known for a long time. The simplest route is the condensation reaction of aldehydes such as formaldehyde with appropriately substituted amines, in particular alkylamines. Various synthetic routes for these complexing ligands are described, for example, 10 in Beilstein, "Handbook of Organic Chemistry", 4th Ed., Vth Suppl. Series, Springer-Verlag, Berlin, Vol. 26 (1986) p. 3ff and Ref.; R=Octyl: D. Jamois et al J. Polym. Sci., Polym. Chem. Ed. 329 (1993), 1941-1958; A.G. Giumanini, G. Verardo et al. J. Prakt. Chem. 327 (1985), 739-748, K. Bhatia, Exoon Chemical 15 Patents inc., EP 620266 (1994); F. Seng, K. Ley, Bayer AG, DE 2431862 (1979); H.J. Ha, G.S. Nam, Korea Institute of Science and Technology, DE 4100856 (1991) and H. Möhrle, D. Schnödelbach, Pharmazie 30 (1975), 699-706. The metal complexes, in particular the chromium complexes, can be obtained in a simple manner by 20 reacting the corresponding metal chlorides or metal carbonyls with the ligand.

The following examples illustrate the invention.

- 25 The following abbreviations and measurement methods were employed:

The comonomer content of the polymers (%C₆) and their methyl side chain content per 1 000 carbon atoms of the polymer chain

- 30 (CH₃/1 000) were determined by IR spectroscopy.

The η value was determined by means of an automatic Ubbelohde viscometer (Lauda PVS 1) using decalin as solvent at 130°C (ISO1628 at 130°C, 0.001 g/ml of decalin). The density was

- 35 determined in accordance with ISO 1183.

- The determination of the molecular weight distributions and the mean values M_n , M_w and M_w/M_n derived therefrom was carried out by means of high-temperature gel permeation chromatography using a 40 method based on DIN 55672 under the following conditions: solvent: 1,2,4-trichlorobenzene, flow: 1 ml/min, temperature: 140°C, calibration using PE standards.

Abbreviations:

- 45 Tp polymerization temperature
M_w weight average molecular weight
M_n number average molecular weight

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Q	polydispersity (ratio of M_w to M_n)
m.p.	melting point of the polymer
η	Staudinger index (viscosity); eta value
$CH_3/1000$	number of methyl side chains per 1 000 carbon atoms
5 MAO	methylaluminoxane
Am	pentyl
^t Bu	tert-butyl
Bz	benzyl
Cy	cyclohexyl
10 Do	dodexyl [sic]
Me	methyl
Oc	octyl
Phet	1-(S)-phenylethyl
iPr	isopropyl
15 TAC	1,3,5-triazacyclohexane
Tf	triflate
Xy	1,3-xylene-1,3-diyl

Example 1:

20 Preparation of 1,3,5-trioctyl-1,3,5-triazacyclohexane (Oc_3TAC)

- 100 g (0.774 mmol [sic]) of octylamine were added in small portions to a suspension of 20.2 g (0.673 mmol [sic]) of paraformaldehyde in 500 ml of toluene which had been cooled to 0°C
- 25 and the mixture was then heated to boiling, resulting in the paraformaldehyde going into solution. Toluene and water were distilled off. The residue was freed of remaining volatiles in an oil pump vacuum and then taken up in 100 ml of methanol, filtered through a short silica gel column and all volatile constituents
- 30 were subsequently removed in an oil pump vacuum. The product was obtained as a viscous clear liquid in a yield of 82.3 g (83%).

Preparation of (Oc_3TAC) $CrCl_3$

- 35 662 mg (1.768 mmol) of $CrCl_3(THF)_3$ and 728 mg (1.855 mmol) of Oc_3TAC were placed in a flask. 100 ml of dry ether were condensed into the flask and the resulting suspension was stirred for about half an hour. After filtration through a frit, the residue on the filter was washed with ether until the filtrate no longer
- 40 displayed a green color. The product was dried thoroughly under reduced pressure. Yield: 885 mg (98%).

Example 2:

Preparation of 1,3,5-tripentyl-1,3,5-triazacyclohexane (Am_3TAC)

4.35 g (49.9 mmol) of n-pentylamine were added in small portions to a suspension of 1.44 g (48 mmol) of paraformaldehyde in 50 ml of toluene which had been cooled to 0°C and the mixture was then heated to boiling, resulting in the paraformaldehyde going into solution. Toluene and water were distilled off. The residue was freed of remaining volatiles in an oil pump vacuum and then taken up in 50 ml of methanol, filtered through a short silica gel column and all volatile constituents were subsequently removed in an oil pump vacuum. The product was obtained as a viscous clear liquid in a yield of 4.47 g (15 mmol; 94%).

15 Preparation of $(\text{Am}_3\text{TAC})\text{CrCl}_3$

532 mg (1.42 mmol) of $\text{CrCl}_3(\text{THF})_3$ and 458 mg (1.54 mmol) of Am_3TAC were placed in a flask. 100 ml of dry ether were condensed into the flask and the resulting suspension was stirred for about half an hour. After filtration through a frit, the residue on the filter was washed with ether until the filtrate no longer displayed a green color. The product was thoroughly dried under reduced pressure. Yield: 557 mg (86%).

25 Example 3:

Polymerizations:

The appropriate amount of MAO (as a 30% strength solution in toluene, manufacturer: Albemarle) and 400 ml of isobutane were placed in a 1 l autoclave. After the autoclave had been pressurized with ethylene to a pressure of 40 bar and heated to 70°C, the appropriate amount of catalyst was in each case introduced via a lock. After 60 minutes, the polymerizations were stopped by venting.

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Polymerization conditions and product property data are shown in Table 1.

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Table 1:

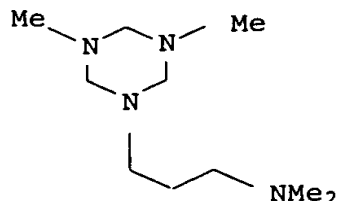
Sample	Amount [mg]	MAO [mmol]	Al:Cr	T _p [°C]	Activity [kg/molCrh]	Yield [g]([min])	Density [g/cm ³]	Eta [dl/g]	M _w [g/mol]	M _n [g/mol]	Q
Complex (Am ₃ TAC) CrCl ₃	49 (107 μmol)	35	325	70	4130	74 (10)	0.9741	0.34	5282	1345	- 3.93
(Oc ₃ TAC) CrCl ₃	6 (10 μmol)	5	500	70	14844	153 (60)	0.9585	0.73	39792	10608	3.75
(Am ₃ TAC) CrCl ₃	6 (13 μmol)	5	384	70	13083	172 (60)	0.966	1.21	40165	8894	4.52

Example 4

Preparation of $\text{Me}_2(\text{Me}_2\text{NCH}_2\text{CH}_2\text{CH}_2)\text{TAC}$

5

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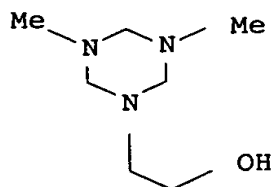
140 g of formaldehyde solution in water (37%, 1.73 mol) were added to a mixture of 50 ml of methylamine solution in water (40%, 580 mmol) and 34 ml of N,N-dimethyltrimethylenediamine (276 mmol) while cooling in ice. 250 g of KOH were added over a period of 2 hours and the mixture was stirred for another 20 hours. The organic phase was separated off and the aqueous phase was extracted a number of times with Et_2O . The combined organic phases were washed with water, evaporated and fractionally distilled at about 10^{-2} torr. The crude product was distilled off as a colorless liquid at $50-60^\circ\text{C}$.
Yield: 9 g (16%)

^1H NMR (CDCl_3 , 80 MHz): 3.03s (4H, MeNCH_2NR), 2.95s (2H, MeNCH_2NMe), 2.34t ($J = 7.3$ Hz, 2H, NCH_2), 2.08t ($J = 7$ Hz, 2H, CH_2NMe_2), 2.01s (6H, MeN), 1.98s (6H, NMe_2), 1.42m (2H, CCH_2C)

Example 5

Preparation of $\text{Me}_2(\text{HOCH}_2\text{CH}_2)\text{TAC}$

35

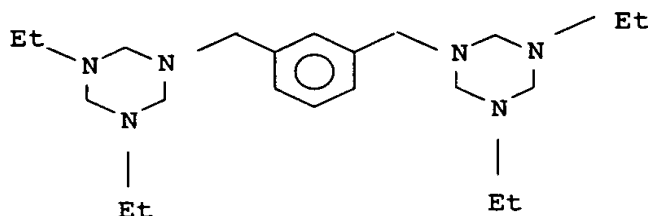


1 ml of ethanolamine (17 mmol) were dissolved in 80 ml of Me_3TAC and heated at 130°C for 12 hours (evolution of gas). Distilling off the excess Me_3TAC ($60^\circ\text{C}/0.01$ torr) gave 2 g of crude product. 10 ml of methylamine (40% in water) were added, the mixture was stirred for 12 hours and the volatiles were again removed under reduced pressure. The residue was volatilized and recondensed by

The procedure of Example 5 was repeated using 1 ml of ethanolamine (17 mmol) and 80 ml of Et₃TAC to give 1.4 g of

¹H NMR (CDCl₃, 200 MHz): 5.74br (1H, HO), 3.62t (2H, CH₂OH), 3.29br (6H, NCH₂N), 2.85t (2H, NCH₂CH₂OH), 2.24t (4H, NCH₂CH₃), 0.99q (4H, NCH₂CH₃).

Preparation of 1,3-di(1-methylene-3,5-diethyl-1,3,5-triazacyclohexyl)benzene



Yield: 22 g (86%)

¹H NMR (CDCl₃, 200 MHz): 7.1–6.7 (4H, aromatic CH), 3.60t (4H, NCH₂), 3.29br (6H, NCH₂N), 2.42t (8H, NCH₂CH₃), 0.99q (12H, NCH₂CH₃)

Example 8

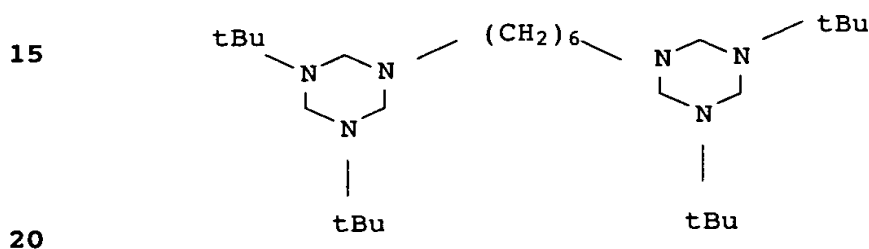
Preparation of 1,3-di(1-methylene-3,5-dimethyl-1,3,5-triazacyclohexyl)benzene

5 The synthesis was carried out by a method analogous to Example 7.

^1H NMR (CDCl_3 , 200 MHz): 7.4-6.9 (4H, aromatic CH), 3.67t (4H, NCH_2), 3.19br (6H, NCH_2N), 2.16s (12H, NMe_2)

10 Example 9

Preparation of 1,6-di(1-3,5-di-tert-butyl-1,3,5-triazacyclohexyl)hexane



While cooling by means of water, 15 g of paraformaldehyde (500 mmol) were added to 39 g of $^t\text{BuNH}_2$ (535 mmol) and 1.2 g of 1,6-diaminohexane (10 mmol). After stirring the mixture for 25 30 minutes, 7.5 g of KOH were added and the mixture was stirred for another 30 minutes. The organic phase was taken off and $^t\text{Bu}_3\text{TAC}$ was distilled off at $100^\circ\text{C}/0.01$ torr. The residue was taken up in 10 ml of pentane, filtered and the solution was cooled to -78°C (dry ice). The precipitate formed was separated 30 off, recrystallized from 10 ml of pentane at -78°C and dried under reduced pressure.

Yield: 2.6 g (50%) of a colorless solid, m.p. $85-90^\circ\text{C}$

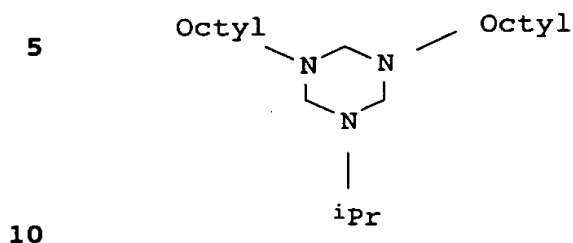
^1H NMR (CDCl_3 , 200 MHz): 3.44 br (4H, $^t\text{BuNCH}_2\text{N}^t\text{Bu}$), 3.33br (8H, $^1\text{BuNCH}_2\text{NCH}_2$), 2.39t (4H, NCH_2), 1.2-1.3m (8H, CH_2), 0.98s (18H, ^tBu)

40

45

Example 10

Preparation of 1-isopropyl-3,5-octyl-1,3,5-triazacyclohexane



130 g of n-octylamine (1.0 mol) were added to 120 g of formalin (37% in water) and 200 ml of methanol (warming) and stirred in a waterbath for 2 hours. After addition of 400 ml of hexane, the organic phase was separated off, washed with water and freed of solvent under reduced pressure. This gave 150 g of a colorless oil which, according to NMR, consists of a mixture of Oc₃TAC and 1-3,5-dioctyloxa-1,5-diazacyclohexane.

2.2 g of this mixture were admixed with 0.8 g of isopropylamine and a little p-toluenesulfonic acid. After 2 days, the mixture was washed with aqueous KOH, then with water, dissolved in pentane, filtered through aluminum oxide and the solvent was removed under reduced pressure. This left a mixture of Oc₃TAC and ⁱPrOc₂TAC.

A solution of the mixture in toluene was dried by means of sodium, filtered, admixed with excess CrCl₃ and a little zinc powder and heated to boiling. The CrCl₃ went into solution (violet). After cooling, the mixture was chromatographed on a silica gel column using first CHCl₃ and then acetone. The separate violet bands of [Oc₃TACCrCl₃] and [ⁱPrOc₂TAC CrCl₃] were collected and the solvent was removed.

Example 11

Preparation of 1,3,5-trimethyl-1,3,5-triazacyclohexane

1,3,5-Trimethyl-1,3,5-triazacyclohexane (0.1 ml, 0.71 mmol) (dried over molecular sieves) was added to a solution of (THF)₃CrCl₃ (117 mg, 0.47 mmol) in 20 ml of THF at room temperature. After stirring for 30 minutes, the violet precipitate was filtered off and washed with diethyl ether. Drying under reduced pressure gave 122 mg (90%) of violet powder (melting point: 270°C (decomp.)).

Example 12

Preparation of 1,3,5-tridodecyl-1,3,5-triazacyclohexane

103.5 g of dodecylamin (558 mmol) were dissolved in 200 ml of
5 toluene, after which 16.75 g of paraformaldehyde (558 mmol) were
added. After stirring the mixture for 1 hour, the toluene/water
azeotrope was distilled off until a boiling point of 110°C had
been reached. The remaining toluene was distilled off on a rotary
evaporator, the residue was dissolved in 1 l of ethanol and
10 cooled to -30°C. The resulting colorless solid was cooled at -30°C
after standing for 2 hours and the solid was, after filtration,
combined with the first. Drying under reduced pressure gave 103 g
of Do₃TAC (94%) as a colorless, viscous liquid.

15 Melting point: 183°C

IR (KBr, v/cm⁻¹): 919m, 948m, 1020m, 1094m, 1114m, 1131m, 1157w,
1172w, 1216w, 1245w, 1261w, 1320w, 1327w, 1336w, 1360w, 1378w,
1396w, 1457m, 1469m, 2851s, 2872s, 2921s, 2954s

UV/Vis (THF) in nm (ε in cm⁻¹ mol⁻¹): 718 (680), 505 (1280), 338

20 (3390)

Magnetic moment by the Evans method: 3.80 μ_B

Preparation of [1,3,5-tridodecyl-1,3,5-triazacyclohexane]chromium
trichloride

25

a) 40 ml of ether (dried over Na/benzophenone) were condensed
onto 2.02 g of [CrCl₃(THF)₃] (5.4 mmol) and 3.20 g of Do₃TAC
(5.4 mmol) and the suspension was stirred for 30 minutes. The
violet solid was separated off by filtration and washed with
30 ether. Drying under reduced pressure gave 3.65 g of product
(90%).

b) 40.4 g of Do₃TAC (68 mmol) were dissolved in 500 ml of
toluene. After a few ml of toluene had been distilled off
35 (boiling point: 110°C) and the solution had been cooled in a
stream of argon, 11.4 g of anhydrous CrCl₃ (72 mmol) were
added. After again distilling off a few ml of toluene and
cooling in a stream of argon, 1.0 g of Zn powder was added.
After distilling off the chloroform, the violet, solid
40 residue was washed with ether and dried under reduced
pressure. The residue was dissolved in chloroform and
purified by column chromatography over silica gel (200 ml).
The violet solution eluted by means of chloroform was
collected and the solvent was removed under reduced pressure.
45 This gave 36.3 g (71%) of the violet complex.

Example 13

Preparation of [1,3,5-tricyclohexyl-1,3,5-triazacyclohexane]-vanadium trichloride

- 10 ml of THF (dried over Na/benzophenone) were condensed onto
5 600 mg of $[\text{VCl}_3(\text{THF})_3]$ (1.6 mmol) and 590 mg of cyclohexyl₃TAC (1.8 mmol) and the suspension was stirred for 60 minutes. The violet solid was separated off by filtration and washed with 2 ml of THF. Drying under reduced pressure gave 0.65 g of product (80%).
- 10 Melting point: 240 - 241°C.
¹H NMR (200 MHz, $\text{CD}_3\text{NO}_2/\text{CDCl}_3(1:2)$): δ 32.4 (3H, $\Delta v_{1/2}$ 80 Hz), 2.82 (6H, $\Delta v_{1/2}$ 37 Hz), 2.08 (6H, $\Delta v_{1/2}$ 70 Hz), 1.07 (3H, $\Delta v_{1/2}$ 15 Hz), 0.98 (3H, $\Delta v_{1/2}$ 21 Hz), 0.92 (6H, $\Delta v_{1/2}$ 14 Hz), -0.07 (6H, $\Delta v_{1/2}$ 17 Hz), -3.66 (3H, $\Delta v_{1/2}$ 180 Hz), -4.16 (3H, $\Delta v_{1/2}$ 82 Hz)
- 15 IR (KBr, v/cm^{-1}): 442m, 518w, 540s, 841m, 896m, 918s, 948s, 974s, 988s, 1017s, 1032s, 1042m, 1053s, 1068s, 1078sm, 1095s, 1120s, 1152m, 1171s, 1193m, 1199s, 1211m, 1257m, 1277m, 1312m, 1337m, 1351m, 1380s, 1395m, 1408m, 1447s, 1452s, 1465s, 1485m, 2853s, 2929s, 2964s, 2991m
- 20 Reflectance UV/vis (KBr compact) in nm: 853, 546, 408

Example 14

- Preparation of [1,3,5-trioctyl-1,3,5-triazacyclohexane]chromium
25 tristriflate

- 10 ml of trifluoromethanesulfonic acid (TfOH) were condensed onto 1.1 g of $[(\text{octyl})_3\text{TAC}]\text{CrCl}_3$ (1.9 mmol). During thawing, the complex dissolved in the acid with evolution of gas (HCl) to give
30 a turquoise solution. The gas was continuously distilled off at room temperature under reduced pressure. Washing with ether and drying under reduced pressure gave 1.2 g (70%) of the turquoise product.

35 Example 15

Preparation of 1-benzyl-3,5-dimethyl-1,3,5-triazacyclohexane

- 9 ml of benzylamine (82 mmol) and 100 ml of methylamine (40% strength in water, 1.2 mol) were dissolved in 500 ml of ethanol,
40 after which 40 g of paraformaldehyde (1.33 mol) were added and the mixture was stirred. After the paraformaldehyde had dissolved and the solution had been cooled to room temperature, the solvent was removed on a rotary evaporator and the residue was distilled at 80-90°C/1.3 Pa. The distillate was dissolved in pentane and
45 stirred with sodium for 48 hours. Filtration and removal of the solvent under reduced pressure left 5 g (30%) of a colorless oil.

22

MS (70 eV, 80°C): 205 (M^+ , 34%), 204 $(-H)^+$, 23%), 162

(($M-(H_2C=NMe)^+$), 58%)

1H NMR (200 MHz, $CDCl_3$): δ 7.3-7.1 (5H, Ph), 3.7s (2H, CH_2Ph), 3.2br (6H, ring CH_2), 2.2s (6H, Me)

5 ^{13}C -NMR (50 MHz, $CDCl_3$): δ 139.6, 128.4, 128.0, 126.7 (Ph), 78.3, 74.7 (ring CH_2), 56.6 (CH_2Ph), 39.9 (Me)

IR (KBr, v/cm^{-1}): 461m, 481m, 699m, 743m, 836m, 862s, 917m, 982s, 1003m, 1009m, 1028m, 1050s, 1062s, 1076s, 1114m, 1144m, 1195s, 10 1234m, 1263w, 1311w, 1361m, 1384m, 1396s, 1418s, 1427s, 1453w, 1469m, 1495s, 1585s, 1605s, 1682s, 2601s, 2627s, 2642s, 2684s, 2726s, 2790w, 2838s, 2852s, 2939w, 2965m, 3027s, 3061s

Preparation of [1-benzyl-3,5-dimethyl-1,3,5-triazacyclohexane]-
15 chromium trichloride

1.0 g of (benzyl) Me_2TAC (4.9 mmol) and 1.8 g of $CrCl_3(THF)_3$ (4.8 mmol) were stirred in 20 ml of diethyl ether. After 30 minutes, the solvent was removed under reduced pressure, more
20 ether was added and removed again under reduced pressure a total of three times, the residue was then washed with ether and dried under reduced pressure. This gave 1.2 g of violet
[[(benzyl) Me_2TAC] $CrCl_3$] (68%), melting point: 244-246°C.
MS (70 eV, 200°C): 290 ($(M-2(HCl))^+$, 1%)
25 Elemental analysis (calc.): C 38.8 (39.6), H 5.7 (5.3), N 10.9 (11.6), Cl 28.7 (29.3)

IR (KBr, v/cm^{-1}): 413m, 422m, 470m, 512s, 558m, 660m, 708m, 769m, 884m, 888m, 892m, 897m, 924w, 944w, 962m, 971m, 1009w, 1028m, 30 1070m, 1103w, 1118w, 1139m, 1164w, 1186m, 1205m, 1259w, 1278w, 1304m, 1341m, 1366s, 1384s, 1424m, 1453m, 1465w, 1480s, 1496s, 1584s, 1640s, 1685s, 2795m, 2876m, 2929s, 2980s, 3005s, 3029s, 3061m, 3086m, 3106m

35 Example 16

Preparation of 1,3-dimethyl-5-octyl-1,3,5-triazacyclohexane

9 ml of octylamine (55 mmol) and 100 ml of methylamine (40% strength in water, 1.2 mol) were dissolved in 500 ml of ethanol,
40 after which 40 g of paraformaldehyde (1.33 mol) were added and the mixture was stirred. After the paraformaldehyde had dissolved and the mixture had cooled to room temperature, the solvent was taken off on a rotary evaporator and the residue was distilled at 90°C/1.3 Pa. The distillate was dissolved in pentane and stirred
45 with sodium for 48 hours. Filtration and removal of the solvent under reduced pressure left 8 g (65%) of a colorless oil.
MS (70 eV, 23°C): 226 ($(M-H)^+$, 4%) 184 ($(M-H_2C=nMe)^+$, 10%)

¹H NMR (200 MHz, CDCl₃): δ 3.2br (6H, ring CH₂), 2.5t (2H, N-CH₂C₇H₁₅), 2.2s (6H, Me), 1.2-1.4 (12H, N-CH₂C₆H₁₂Me), 0.8t (3H, N-CH₂C₆H₁₂Me)

5 (N-CH₂C₇H₁₅), 40.0 (Me), 31.6, 29.3, 29.1, 27.8, 27.2, 22.5, 13.9
(N-CH₂C₇H₁₅)

IR (KBr, ν/cm^{-1}): 724m, 834m, 860m, 864m, 915m, 981w, 1003s, 1026m, 1049m, 1116s, 1147s, 1234m, 1262s, 1370m, 1385m, 1426w,

Preparation of [1,3-dimethyl-5-octyl-1,3,5-triazacyclohexane]-chromium trichloride

15 1.5 g of (octyl)Me₂TAC (6.6 mmol) and 2.4 g of CrCl₃(THF)₃ (6.4 mmol) were stirred in 20 ml of diethyl ether. After 30 minutes, the solvent was removed under reduced pressure, more ether was added and removed again under reduced pressure a total of three times, the residue was then washed with ether and dried

20 under reduced pressure. This gave 2.1 g of violet $[(\text{octyl})\text{Me}_2\text{TAC})\text{CrCl}_3]$ (82%), melting point: 187°C.

MS (70 eV, 200°C): 312 ((M-2(HCl))⁺, 18)

plus some 410 $((M' - 2(HCl))^+)$ of $[((octyl)_2MeTAC)CrCl_3]$

Elemental analysis (calc.): C 41.3 (40.5), H 7.7 (7.6), N 10.7

25 (10.9), C1 25.5 (27.6)

calculated for mixture with 8% of $[(\text{octyl})_2\text{MeTAC}]\text{CrCl}_3$: C 41.4, H 7.7, N 10.7, Cl 27.0

IR (KBr, v/cm^{-1}): 420m, 512w, 531s, 535s, 539s, 543s, 724s, 925w,

30 1006w, 1083w, 1116w, 1168m, 1236s, 1257m, 1281s, 1378s, 1418s,
1469m, 1642s, 1687s, 2855s, 2927m, 2956s

Preparation of [1,3,5-tri(S-1-phenylethyl)-1,3,5-triazacyclohexane]chromium trichloride

540 g of $[\text{CrCl}_3(\text{THF})_3]$ (1.45 mmol) and 550 mg of (S-Phet) $_3$ TAC (1.38 mmol) were stirred in 20 ml of THF for 7 days until a sample of the suspension mixed with water gave a colorless

40 solution and a violet precipitate. After addition of 60 ml of water, the violet solid was separated off by filtration and washed a number of times with ether. Drying under reduced pressure (40°C, 2 hours) gave 680 mg of product (90%).

Melting point: 313°C (slow decomposition above 250°C)

45 Specific rotation in CH_2Cl_2 ($c = 0.2 \text{ g/100 ml}$) : $[\alpha]_{\text{D}}^{20} = -286^\circ$

24

IR (KBr, ν/cm^{-1}): 473m, 480m, 507m, 533m, 564s, 583m, 618m, 652m, 658m, 670m, 704s, 710s, 753s, 769m, 780s, 833m, 854m, 890m, 931s, 974s, 996s, 1009s, 1027s, 1032s, 1042s, 1055s, 1080s, 1105s, 1158s, 1168s, 1193m, 1204s, 1212s, 1231m, 1257s, 1310m, 1356m, 1366m, 1386s, 1394m, 1403m, 1453s, 1477m, 1497s, 1583m, 1602m, 1617m, 1899, 1974m, 1995m, 1865s, 2937s, 2979s, 3005m, 3028m, 3036m, 3062m

UV/Vis (THF) in nm (ϵ in $\text{cm}^{-1}\text{mol}^{-1}$): 739 (140), 526 (280), 342 (23)

10

Examples 18 to 38

Procedure for the polymerization experiments

The polymerization experiments were carried out under argon using 15 in each case between 5 to 20 μmol of the complexes (see Table 2) in 250 ml of absolute toluene at 40°C.

In the activation experiments using MAO, in each case the amount of 1.6 molar MAO in toluene indicated in Table 2 was added. When 20 activation was carried out using borate, the appropriate amount of DMAB (dimethylanilinium tetrakis(pentafluorophenyl)borate) was added, the mixture was heated to 70°C and subsequently admixed with Tibal (triisobutylaluminum) as indicated in Table 2. The solution was cooled again to 40°C. About 20-40 l/h of ethylene 25 were then passed through the solution for one hour (at atmospheric pressure). In the copolymerization experiments, 5 ml of hexene were initially introduced before the ethylene was passed through the solution, after which ethylene was passed through and the remaining amount of hexene was added via a 30 dropping funnel over a period of 15 minutes. When butene was used, about 10-20 l/h of butene were passed through the solution together with the ethylene.

The reaction was stopped by addition of a mixture of 15 ml of 35 concentrated hydrochloric acid and 50 ml of methanol and the mixture was stirred for another 15 minutes. After addition of 250 ml of methanol, the solid was filtered off, washed with methanol and dried at 70°C. Polymerization and product data are summarized in Table 2.

40

45

Table 2

Ex.	Complex	Amount of complex		MAO [mmol]	Al:Cr	Cr:B ¹	Comonomer [ml]	T _p [°C]	Activity [kg/molCr.h]
		[mg]	[μmol]						
18	[Am ₃ TAC]CrO ₃	6.5	14.3	5.3	370:1	-	-	43	552
19	[Am ₃ TAC]CrO ₃	7.0	14.9	5.3	355:1	-	-	40	52.7
20	[Oc ₃ TAC]CrTf ₃	13.7	14.8	5.3	360:1	-	-	40	554
21	[Oc ₃ TAC]CrCl ₃	8.8	15.1	5.3	350:1	-	-	40	490
22	[tBu ₃ TAC]CrCl ₃	6.5	15.7	5.3	340:1	-	-	40	7.9
23	[tBu ₃ TAC]CrCl ₃	12.8	30.9	10.5	343:1	-	-	40	38.8
24	[Me ₂ DotAC]CrCl ₃	12.7	15.2	5.3	350:1	-	-	40	3.3
25	[Do ₃ TAC]CrCl ₃	12.5	16.6	5.3	320:1	-	-	40	717
26	[Do ₃ TAC]CrCl ₃	15.2	20.2	-	80:1	1:1.5	(C ₆) ₂ 30	40	390
27	[Do ₃ TAC]CrCl ₃	23.2	30.9	-	18.6:1	1:1.44	-	40	324
28	[Do ₃ TAC]CrCl ₃	15.5	20.6	-	60:1	-	-	40	85
29	[Cy ₃ TAC]CrCl ₃	11.9	15.2	5.3	348:1	-	-	40	5.3
30	[Me ₃ TAC]CrCl ₃	4.8	16.7	7.9	473:1	-	-	40	455
31	[Me ₃ TAC]CrCl ₃	5.2	18.1	-	50:1	1:1.68	-	40	590
32	[Cy ₃ TAC]VCl ₃	8.3	16.9	10.6	627:1	-	-	40	5.3
33	([iPr-TAC] ₂ XY)CrCl ₃	11.6	15.2	5.3	348:1	-	-	40	6.6
34	[PhEt ₃ TAC]CrCl ₃	8.7	15.6	5.49	352:1	-	-	40	135

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Ex.	Complex	Amount of complex		MAO	Al:Cr	Cr:B ¹	Comonomer	T _p	Activity
35	[Bz ₃ TAC]CrCl ₃	9.2	17.8	6.3	354:1	-	-	40	15.2
36	[Bz ₃ TAC]CrCl ₃	11.2	21.7	-	28:1	1:1.44	-	40	5.5
37	[DO ₃ TAC]CrCl ₃	12.5	16.7	5.85	350:1	-	(C ₄) ²	40	215
38	[PhEt ₃ TAC]CrCl ₃	10.3	18.4	5.54	300:1	-	(C ₆) ² 30	40	180

Ex.	Yield		Density	Eta	M _w	M _n	Q	C6 ³	m.p.	CH ₃ /1000
	[g]	[min]	[g/cm ³]	[dl/g]	[g/mol]	[g/mol]		[%]	[°C]	[/1000C]
18	7.9	60	-	2.62	133258	12047	11.06	-	135.9	<1
19	52.7	60	0.9565	6.97	812171	19081	42.56	-	144.5	1.3
20	8.2	60	-	1.38	131969	15165	8.70	-	134.7	1.7
21	7.4	60	0.9610	1.05	28676	7641	3.75	-	130.7	2.0
22	0.124	60	-	4.36	-	-	-	-	-	-
23	1.20	60	0.9661	0.17	2599	1459	1.78	-	122.8	11.8
24	0.05	60	-	3.5	-	-	-	-	-	-
25	11.9	60	0.9570	1.04	27967	9804	2.085	-	128.9	2.6
26	7.9	60	0.9458	3.83	-	-	-	1.7	125.1	8.7
27	10	60	0.9621	0.65	23078	7317	3.15	-	128.8	3.0
28	1.75	60	0.9492	14.69	-	-	-	-	139.7	<1
29	0.08	60	-	17.2	-	-	-	-	-	-
30	7.6	60	0.09595	1.68	37004	12008	3.08	-	132.6	1.7
31	7.1	60	0.9631	2.66	208752	4834	43.2	-	135.2	1.3

12 comonomer

[D₃TAC]GaCl₃
3/22/12

GK

2/6
(03/09/03)
350/L

Ex.	Yield		Density	Eta	M _w	M _n	Q	C6 ³	m.p.	CH ₃ /1000
32	0.09	60	-	6.22	-	-	-	-	-	-
33	0.1	60	-	8.12	-	-	-	-	-	-
34	2.1	60	0.9661	0.59	19879	6613	3.01	-	129.7	2.9
35	0.27	60	-	24.0	-	-	-	-	-	-
36	0.12	60	-	25.3	-	-	-	-	-	-
37	3.6	60	0.9504	3.87				-	137	3.2
38	3.3	60	0.9469	1.69	124363	13989	8.89	1.3	126.1	3.5

1 Activation is carried out by addition of N,N-dimethylanilinium tetra(pentafluorophenyl)borate

2 C₆ = 1-Hexene

C₄ = 1-Butene

3 C₆ = 1-Hexene incorporated in the polymer

Examples 39 to 45

- The polymerizations were carried out in a 1 l four-necked flask provided with contact thermometer, stirrer with Teflon blade, heating mantle and gas inlet tube. Under argon, from 10 to 20 μ m of (Do₃TAC)CrCl₃ in 250 ml of absolute toluene were in each case placed in the flask at 40°C. The amount of dimethylanilinium tetrakis(pentafluorophenyl)borate indicated in Table 3 was then added, the mixture was heated to 70°C and subsequently admixed with Tibal (triisobutylaluminum) in a Cr:Al ratio of 1:50. The solution was cooled again to 40°C and about 20-40 l/h of ethylene were subsequently passed through it for from 20 to 60 minutes.
- 15 The reaction was stopped by addition of a mixture of 15 ml of concentrated hydrochloric acid and 50 ml of methanol and the mixture was stirred for another 15 minutes. 250 ml of methanol were then added, the mixture was stirred for another 15 minutes, the solid was filtered off, washed with methanol and dried at 20 70°C. The polymerization and product data are summarized in Table 3.

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T08260"0822660

10-20 μ m
 (D₃MCOC₃)
 20-40 μ m of 2

Table 3:

Ex.	Complex [μ mol]	Cr:B*	Yield [g] ([min])	Activity [kgPE/molCr·h]	Eta [dl/g]	CH ₃ /1000 C	Density [g/cm ³]	m.p. [°C]
39	18.6	1:1.6	6.3 (60)	338	0.97	2.3	0.9631	-
40	20.4	1:3.7	9.7 (60)	475	4.45	1.9	0.9535	-
41	19.2	1:5.2	7.9 (60)	411	2.63	2	0.9566	-
42	20.4	1:9.8	18 (30)	1765	17.14	<1	0.9313	140.2
43	19.05	1:9.8	13.6 (30)	1428	12.49	1	0.9448	137.4
44	18.8	1:15	15.6 (20)	2502	19.21	<1	0.9317	142.8
45	10.13	1:10.2	16.5 (35)	2790	20.78	<1	0.9308	140.1

* Activation was carried out by addition of N,N-dimethylaniline tetrapentafluorophenyl borate

Example 46

Application to a polystyrene support

- 5 Polystyrene (102 g) was suspended in 700 ml of toluene and stirred at room temperature for 5 hours. The polystyrene was then filtered off and stirred with 800 ml of diethyl ether for 1 day. The polystyrene was filtered off again and subsequently suspended in 800 ml of methanol. After the mixture had been filtered again,
- 10 the solid was once again suspended in 800 ml of methanol and filtered again. The resulting polystyrene was dried under reduced pressure. In this way, purified polystyrene could generally be obtained in a yield of about 90% by weight.
- 15 11.5 g of polystyrene support material were added to a mixture of 863 mg of $(\text{D}_3\text{TAC})\text{CrCl}_3$, 50.1 ml of methylaluminoxane (30% by weight in toluene) ($\text{Al}:\text{Cr} = 200:1$) and 5 ml of toluene and the mixture was stirred at room temperature for 3 hours. Drying under reduced pressure gave 27.4 g of supported catalyst having a
- 20 loading of 100 $\mu\text{mol/g}$ of support.

Examples 47 to 51

- The polymerizations were carried out in a 10 l stirring
- 25 autoclave. Under nitrogen, 100 mg of Tibal (triisobutylaluminum) were placed in the autoclave at room temperature, and 4 l of isobutane were then metered in. For copolymerization of butene, 400 ml of butene were additionally condensed into the autoclave. The mixture was then heated to 70°C while stirring and the amount
- 30 of supported catalyst indicated in Table 4 was subsequently injected by means of ethylene pressure. The reactor pressure was then increased to a final pressure of 40 bar by means of ethylene and the polymerization was continued for one hour.
- 35 The reaction was stopped by venting the reactor and the products were discharged. Table 4 summarizes the polymerization and product data.

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865mg D₂O 70%
 11.5g PS 50%
 50% MAO (30%)

HLG \Rightarrow 100% \Rightarrow super-tx cat. g.p.

Table 4

Ex.	Amount of catalyst [mg]	Yield [g]	t(poly) ¹ [min]	Activity [kg/molCr·h]	C ₄ ² [ml]	H ₂ [bar]	Density [g/cm ³]	Eta [dl/g]	HLM [g/10min]
47	1200	300	70	250	-	-	0.9546	1.00	209.8
48	650	350	40	540	-	-	0.9568	0.93	325
49	902	700	30	800	400	5	0.9640	0.31	
50	410	400	90	1000	400	5	0.9643	0.35	
51	598	950	90	1600	400	-	0.9547	2.67	

¹ t(poly): Polymerization time² C₄: 1-Butene

Example 52

Application to a silica gel support

The silica gel used was ES70X from Crossfield [sic].

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Example 52

32.3 ml of MAO (1.55 M in toluene) (50 mmol) were added to 375 mg of $(\text{DO}_3\text{TAC})\text{CrCl}_3$ (0.5 mmol) dissolved in 21.76 ml of toluene and the mixture was stirred at room temperature for 15 minutes. 5 g of silica gel (calcined at 600°C) were then added to the reaction mixture and the resulting suspension was stirred at room temperature for 6 hours. It was then allowed to stand overnight, the solid was subsequently filtered off and then washed twice with heptane. The solid isolated in this way was dried under reduced pressure. Yield: 8.2 g of supported catalyst.

Examples 53 and 54

The polymerizations were carried out in a 10 l stirring autoclave. Under nitrogen, Tibal (triisobutylaluminum) was introduced into the autoclave at room temperature, after which 4 l of isobutane were condensed in and, if appropriate, 100 ml of hexene were added. The mixture was then heated to 70°C while stirring and the amount indicated in Table 4 [sic] of the supported catalyst from Example 52 was subsequently injected by means of ethylene pressure. The reactor pressure was then increased to a final pressure of 40 bar by means of ethylene and the polymerization was continued for 90 minutes.

The reaction was stopped by venting the reactor and the products were discharged. Table 5 summarizes the polymerization and product data.

Example 55

808 mg of dimethylanilinium tetrakis(pentafluorophenyl)borate (1 mmol) were added to 375 mg of $(\text{DO}_3\text{TAC})\text{CrCl}_3$ (0.5 mmol) dissolved in 300 ml of toluene and the mixture was heated to 75°C. After cooling to room temperature, 5 g of silica gel (calcined at 600°C) were added to the reaction mixture. The suspension was then stirred at room temperature for one hour and the solvent was subsequently removed under reduced pressure. Yield: 6.5 g of supported catalyst (5% of residual toluene).

The polymerizations were carried out in a 1 l stirring autoclave. Under nitrogen, the amount of TEAL (triethylaluminum) indicated in Table 5 was introduced into the autoclave at room temperature, after which 400 ml of isobutane were metered in. The mixture was then heated to 70°C while stirring and the amount indicated in

Table 5 of the supported catalyst from Example 55 was then injected by means of ethylene pressure. The reactor pressure was then increased to a final pressure of 40 bar by means of ethylene and the polymerization was continued for one hour.

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The reaction was stopped by venting the reactor and the products were discharged. Table 5 summarizes the polymerization and product data.

10 Example 56

1454 mg of dimethylanilinium tetrakis(pentafluorophenyl)borate (1.8 mmol) were added to 675 mg of (Do₃TAC)CrCl₃ (0.9 mmol) dissolved in 50 ml of toluene and the mixture was heated to 80°C. After cooling to 50°C, 6 g of silica gel (calcined at 600°C) were

15 added to the reaction mixture. The suspension was then stirred at 80°C for 30 minutes and the solvent was subsequently removed under reduced pressure. Yield: 7.6 g of supported catalyst.

The polymerization was carried out as in Example 55 using the

20 supported catalyst from Example 56. Polymerization conditions and product data are shown in Table 5.

Example 57

485 mg of dimethylanilinium tetrakis(pentafluorophenyl)borate

25 (0.6 mmol) were added to 225 mg of (Do₃TAC)CrCl₃ (0.3 mmol) dissolved in 50 ml of toluene and the mixture was heated to 75°C. After cooling to room temperature, 6 g of silica gel (calcined at 600°C) were added to the reaction mixture. The suspension was then stirred at room temperature for one hour, then allowed to stand
30 for 2 hours and the solvent was subsequently removed under reduced pressure. Yield: 6.8 g of supported catalyst.

The polymerization was carried out as in Example 55 using the

supported catalyst from Example 57. Polymerization conditions and
35 product data are shown in Table 5.

Example 58

970 mg of dimethylanilinium tetrakis(pentafluorophenyl)borate (1.2 mmol) were added to 450 mg of (Do₃TAC)CrCl₃ (0.6 mmol)

40 dissolved in 50 ml of toluene and the mixture was heated to 75°C. After cooling to room temperature, 6 g of silica gel (which had been heated at 130°C under reduced pressure for 6 h) were added to the reaction mixture. The suspension was then stirred at room temperature for an hour, then allowed to stand for 2 hours and
45 the solvent was subsequently removed under reduced pressure. Yield: 7.2 g of supported catalyst.

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The polymerization was carried out as in Example 55 using the supported catalyst from Example 58. Polymerization conditions and product data are shown in Table 5.

5 Example 59

970 mg of dimethylanilinium tetrakis(pentafluorophenyl)borate (1.2 mmol) were added to 450.2 mg of (Do₃TAC)CrCl₃ (0.6 mmol) dissolved in 100 ml of toluene and the mixture was heated to 80°C. After cooling to room temperature, first 15 ml of Tibal (2M in
10 toluene) (15 mmol) and subsequently 6 g of silica gel (calcined at 600°C) were added to the reaction mixture. The suspension was then stirred at room temperature for 1 hour and the solvent was subsequently removed under reduced pressure. Yield: 12.6 g of supported catalyst.

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The polymerization was carried out as in Example 55 using the supported catalyst from Example 59. Polymerization conditions and product data are shown in Table 5.

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Table 5

Ex.	Amount of catalyst [mg]	TEAL ¹ [mg]	Yield [g]	t(poly) ² [min]	Productivity [gPE/gCat]	C ₆ ³ [ml]	Tp [°C]	Density [g/cm ³]	Eta [dl/g]	% C ₆ ⁴ [%]
53	721	150	600	90	830	-	70	0.9554	5.08	
54	1100	150	750	90	700	100	70	0.9547	3.47	1
55	94	50	128	60	1360	-	40-70	0.9453		
56	132	50	90	60	680	-	70	0.9406		
57	107	50	31	60	290	-	70	0.9466		
58	101	50	47	60	465	-	70			
59	141	20	51	60	360	-	70			

¹ TEAL: Triethylaluminum² t(poly): Polymerization time³ C₆: 1-Hexene⁴ % C₆: % by weight of C₆ in the polymer